

Date: Thursday, 04/09/2008 12:50:09 PM  
User: Julie Lecocq

# Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: HELI ACCESS STEP HIGH GEAR RH
<b>Job Number</b>	: 41811	<b>Part Number</b>	: D205633022
<b>Estimate Number</b>	: 12435	<b>Drawing Number</b>	: DSI 9300 REV B
<b>P.O. Number</b>	:	<b>Project Number</b>	: N/A
<b>This Issue</b>	: 04/09/2008	<b>Drawing Revision</b>	: B
<b>Prsht Rev.</b>	: NC	<b>Material</b>	:
<b>First Issue</b>	: / /	<b>Due Date</b>	: 11/09/2008
<b>Previous Run</b>	: 39860	<b>Qty:</b>	1
<b>Written By</b>	:	<b>Um:</b>	Each
<b>Checked &amp; Approved By</b>	: <u>JLD 08.9.04</u>		
<b>Comment</b>	: Est Rev:B Added D2565-111 05-09-09 KJ/JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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JLD 08.9.04



**Comment:** Photocopy bluefile & type labels per PPPD205-633-022 CHG001

S. 08/09/04

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
Pick Packing Kit

3.0	D2022101	Spacer
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacer

Batch: B33985

SL

4.0	D2022103	Spacer
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Spacer

Batch: 25967

SL

5.0	D2562011	Strut
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Strut

Batch: B39882

0/9/14

SL

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP HIGH GEAR RH

Job Number: 41811

Part Number: D205633022

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2565101

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: B38027

SP

7.0

D2565103

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: B38028

SP

8.0

D2565105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: B38029

SP

9.0

D2565107

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: B38030

SP

10.0

D2565109

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: B40012

SP

11.0

D2565111

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: B38031

SP

12.0

D3437041

Aft Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Strut Assembly

Batch: B39869

8/9/17

SP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/09/2008 12:50:09 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP HIGH GEAR RH

Job Number: 41811

Part Number: D205633022

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D3438042

Step Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Step Weldment Assembly

Batch: ~~41811A~~ SP 36525

SP

14.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bolt

Batch: M100857

SP

15.0

AN46A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M102662

M107534

SP

16.0

AN47A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bolt

Batch: M102140

SP

17.0

AN411A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bolt

Batch: M106605

SP

18.0

AN414A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bolt

Batch: M105653

SP

19.0

AN44 7A

EYEBOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

EYEBOLT

Batch: M106763

\*\*\*\*\*ENSURE THIS IS AN44-7A EYEBOLT\*\*\*\*\*

8/9/4

SP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: HELI ACCESS STEP HIGH GEAR RH

Job Number: 41811

Part Number: D205633022

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	AN514A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bolt

Batch: M104547

54

21.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Washer

Batch: M106277

M108161

56

22.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Washer

Batch: 19185

54

23.0	MS21042L4	Nut
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Nut

Batch: M9185

M107499

54

24.0	MS21042L5	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: 106277

84/4

54

25.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

508/02/04 40

26.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-021

Location:

PPP Rev: Draft

84/4

54

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Drawing Name: HELI ACCESS STEP HIGH GEAR RH

Job Number: 41811

Part Number: D205633022

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08-09-04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. 8 SHEET 1 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS
A	05.05.05	NEW ISSUE	
B	05.08.12	ADD STRUTS IF TANK REMOVED	

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-633 REV. A

REF. CANADIAN STC: SH96-57

REF. FAA STC: SR00592NY, SR00593NY, SR00594NY

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO ADD THE D205-633-021/-022/-023/-024/-025/-026 STEPS TO ADDRESS COMPATABILITY WITH THE SIMPLEX MODEL 304 FIRE ATTACK TANK. D205-633-021/-022 ARE IDENTICAL TO D205-633-011, EXCEPT AS SHOWN HERE. D205-633-023/-024 ARE IDENTICAL TO D205-633-013, EXCEPT AS SHOWN HERE. D205-633-025/-026 ARE IDENTICAL TO D205-633-015, EXCEPT AS SHOWN HERE.

NOTE THAT THE STRUTS REQUIRED TO INSTALL THE STEPS ON THE LOWER AFT HARDPOINT HAVE ALSO BEEN INCLUDED WITH THE KITS IN CASE THE TANK IS REMOVED FOR ANY REASON. THESE STRUTS SHOULD BE INSTALLED I.A.W. IIN-D205-633, EXCEPT REPLACE EYEBOLT WITH AN4 BOLT ON LOWER HARDPOINT. ALSO NOTE THAT IF THE THREADS PROTRUDE THROUGH THE BAR ON THE D3437-XXX STRUT ASSEMBLIES AFTER ADJUSTMENT THEY MAY BE TRIMMED OFF.

### WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-633-021 <b>HELI-ACCESS-STEP™</b>	14.0 lb 6.35 kg	-50.0 in -1.27 m	-700 in lb -8.06 m kg	94.5 in 2.40 m	1323 in lb 15.24 m kg
D205-633-022 <b>HELI-ACCESS-STEP™</b>	13.2 lb 6.00 kg	+50.0 in +1.27 m	+660 in lb +7.62 m kg	94.5 in 2.40 m	1247 in lb 14.40 m kg
D205-633-023 <b>HELI-ACCESS-STEP™</b>	14.3 lb 6.50 kg	-50.0 in -1.27 m	-715 in lb -8.26 m kg	94.5 in 2.40 m	1351 in lb 15.6 m kg
D205-633-024 <b>HELI-ACCESS-STEP™</b>	13.5 lb 6.14 kg	+50.0 in +1.27 m	+675 in lb +7.80 m kg	94.5 in 2.40 m	1276 in lb 14.74 m kg
D205-633-025 <b>HELI-ACCESS-STEP™</b>	14.6 lb 6.64 kg	-50.0 in -1.27 m	-730 in-lb -8.43 m-kkg	94.5 in 2.40 m	1380 in-lb 15.94 m-kkg
D205-633-026 <b>HELI-ACCESS-STEP™</b>	13.8 lb 6.27 kg	+50.0 in +1.27 m	+690 in-lb +7.96 m-kkg	94.5 in 2.40 m	1304 in-lb 15.05 m-kkg

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DAO # 01-O-01

**APPROVED**



BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 05.08.12  
CERT. NO.: SH96-57  
ISSUE NO.: #5

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CHECKED 	APPROVED 	DRAWING NO. DSI 9300	REV. B SHEET 2 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS

**PARTS LIST**

QTY -021	QTY -022	QTY -023	QTY -024	QTY -025	QTY -026	Part Number	Description
X						D205-633-021	Heli-Access-Step™ (LH), High Gear
	X					D205-633-022	Heli-Access-Step™ (RH), High Gear
		X				D205-633-023	Heli-Access-Step™ (LH), Extended High Gear (31")
			X			D205-633-024	Heli-Access-Step™ (RH), Extended High Gear (31")
				X		D205-633-025	Heli-Access-Step™ (LH), Extended High Gear (39")
					X	D205-633-026	Heli-Access-Step™ (RH), Extended High Gear (39")
4	4	4	4	4	4	D2022-101	SPACER
2	2	2	2	2	2	D2022-103	SPACER
				1	1	D2562-005	STRUT
1	1					D2562-011	STRUT
		1	1			D2562-013	STRUT
1		1		1		D2563	WELDMENT ASSEMBLY
				*1	*1	D3165-1	STRUT
1	1					D2565-101	STRUT
1	1					D2565-103	STRUT
1	1					D2565-105	STRUT
1	1					D2565-107	STRUT
1	1					D2565-109	STRUT
*1	*1					D2565-111	STRUT
		1	1			D2565-201	STRUT
		1	1			D2565-203	STRUT
		1	1			D2565-205	STRUT
		1	1			D2565-207	STRUT
		1	1			D2565-209	STRUT
		*1	*1			D2565-211	STRUT
				1	1	D2565-301	STRUT
				1	1	D2565-303	STRUT
				1	1	D2565-305	STRUT
				1	1	D2565-307	STRUT
				1	1	D2565-309	STRUT
1	1					D3437-041	AFT STRUT ASSEMBLY
		1	1			D3437-043	AFT STRUT ASSEMBLY
				1	1	D3437-045	AFT STRUT ASSEMBLY
	1		1		1	D3438-042	WELDMENT ASSEMBLY
1	1	1	1	1	1	AN4-5A	BOLT
4	4	3	3	3	3	AN4-6A	BOLT
1	1	1	1	1	1	AN4-7A	BOLT
1	1					AN4-11A	BOLT
		1	1	1	1	AN4-12A	BOLT
1	1	1	1	1	1	AN4-14A	BOLT
1	1	1	1	1	1	AN44-7A	EYEBOLT
1	1	1	1	1	1	AN5-14A	BOLT
16	16	14	14	14	14	AN960JD416	WASHER
3	3	3	3	3	3	AN960JD516	WASHER
8	8	7	7	7	7	MS21042L4	NUT (or MS21042-4)
2	2	2	2	2	2	MS21042L5	NUT (or MS21042-5)

CANADA  
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DAO # 01-O-01

**APPROVED**

BY:   
D. SHEPHERD (DE # 02)

DATE: 05.08.12  
CERT. NO.: SH96-57  
ISSUE NO.: #5

\* ONLY INSTALLED IF TANK IS REMOVED

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**DART**

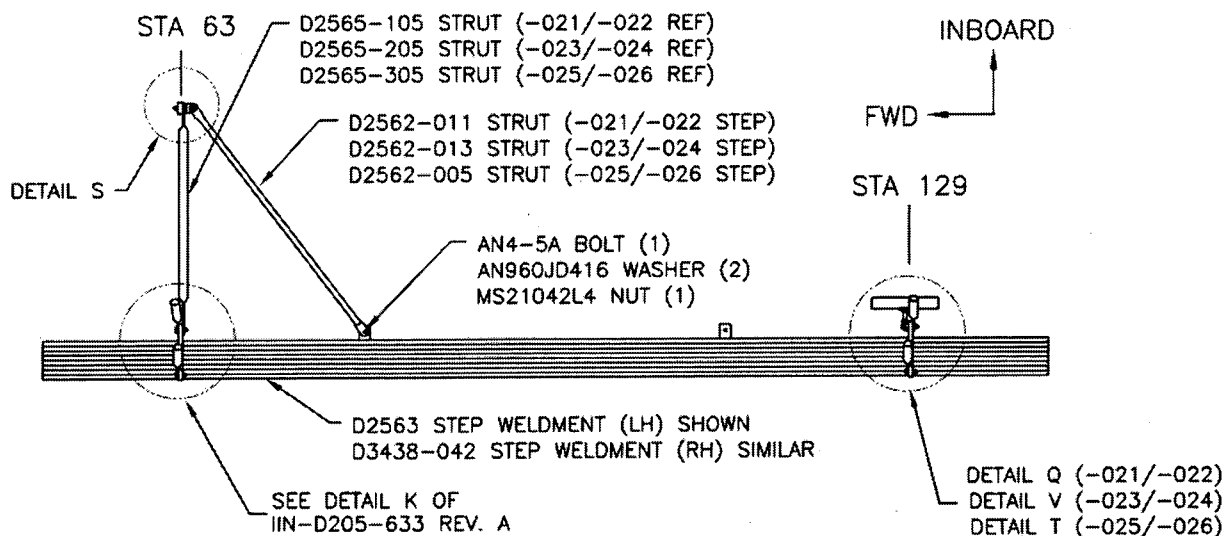
DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. B 3 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP KIT	SCALE NTS

**INSTALLATION OF D205-633-021/-022/-023/-024/-025/-026**

INSTALL D205-633-021/-022 AS PER THE D205-633-011 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-111 STRUT WITH THE D3437-041 AFT STRUT ASS'Y, REMOVE D2562-001 STRUT, INSTALL D2562-011 STRUT AS SHOWN.

INSTALL D205-633-023/-024 AS PER THE D205-633-013 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-211 STRUT WITH THE D3437-043 AFT STRUT ASS'Y, REMOVE D2562-003 STRUT, INSTALL D2562-013 STRUT AS SHOWN.

INSTALL D205-633-025/-026 AS PER THE D205-633-015 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D3165-1 SUPPORT ARM WITH THE D3437-045 AFT STRUT ASS'Y AS SHOWN.

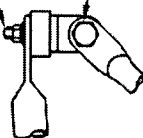


**D205-633-021/-023/-025 SHOWN.**  
**D205-633-022/-024/-026 SIMILAR**  
(VIEW LOOKING DOWN)

AN44-7A EYEBOLT (1)  
AN960JD516 WASHER (1)  
MS21042L5 NUT (1)

AN4-6A BOLT (1)  
AN960JD416 WASHER (2)  
MS21042L4 NUT (1)

**DETAIL S**  
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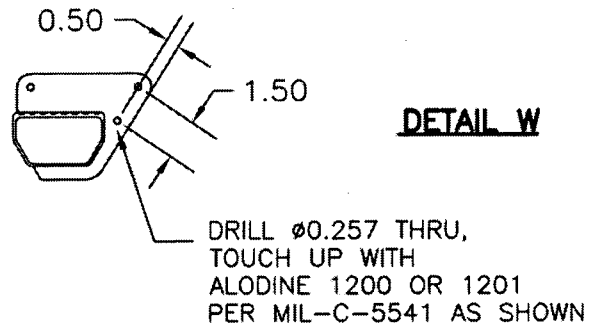
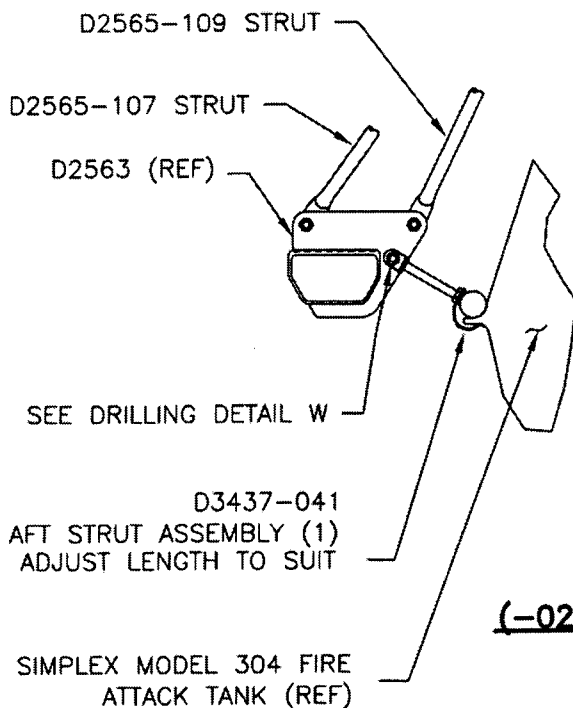
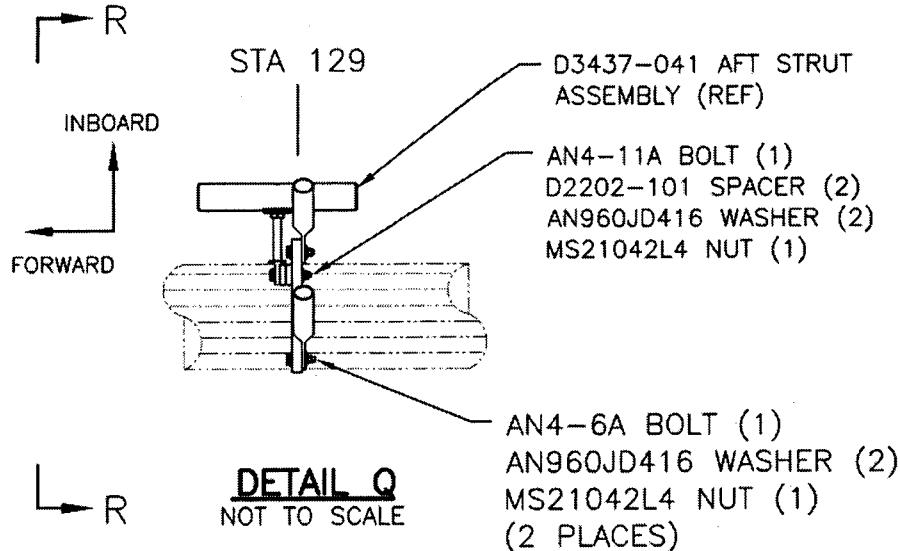
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DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS



**(-021/-022 STEP)**

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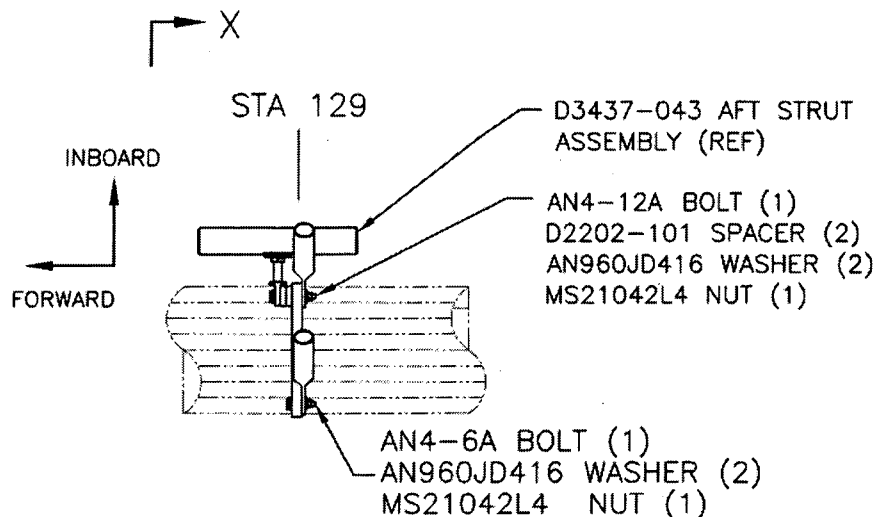
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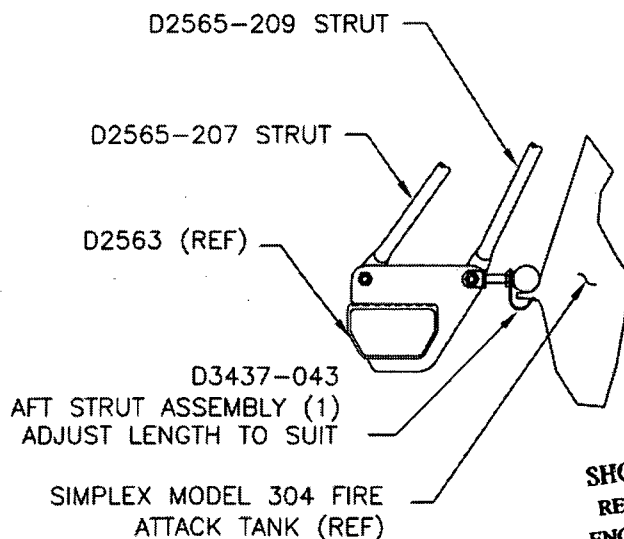
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. B SHEET 5 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS



**DETAIL V**  
NOT TO SCALE



**(-023/-024 STEP)**

**VIEW X-X**  
NOT TO SCALE

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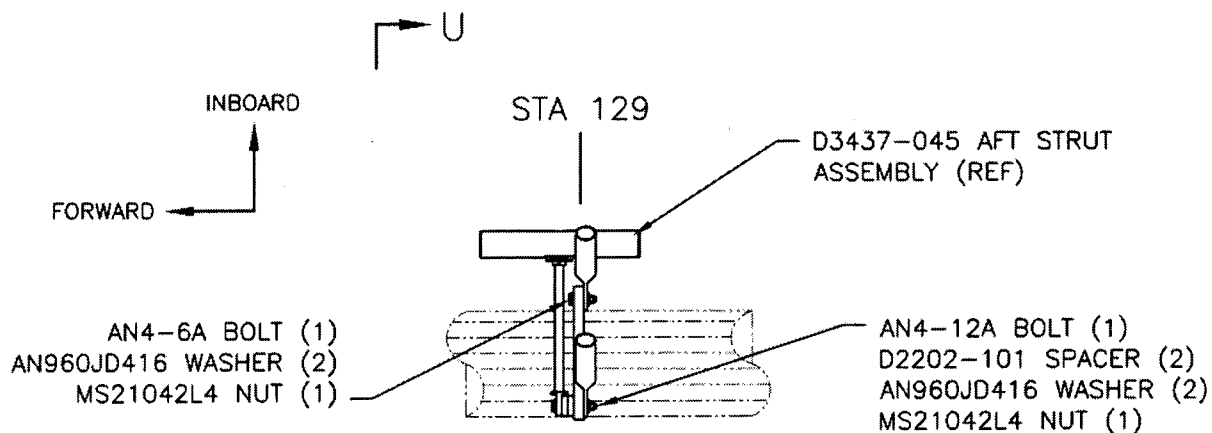
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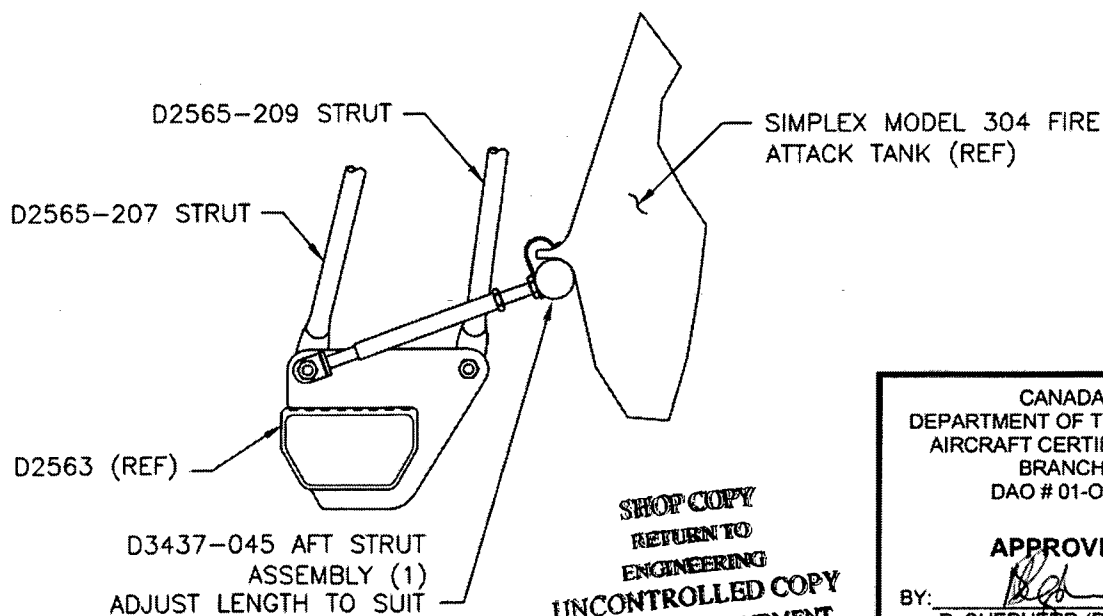
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